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Quality Control

112435

Page 1

January-30-14 11:43:18 AM B112435 Item ID: D3564-9 Accept *N900040100* Setup Start *NS1* **Revision ID:** D 3 5 6 4 - 9 **Item Name:** Stainless Steel Wearplate Fwd **Start Date:** 1/30/14 Start Oty: 8:00 **Cust Item ID:** * XIIX Required Date: 1/30/14 Req'd Qty: 8:00 **Customer:** Reference: Run Start Date: 14-01-31 Tooling: **Approvals: Process Plan:** Date: Stop SPC (Y/N): Date: Date: Sequence ID/ **Operation** Set Up/ **Tool ID** Tool # Plan Accept Reject Reject Insp. Work Center ID Description Qty Stamp Code **Qty** Number **Run Hours Draw Nbr Revision Nbr** D3564 Rev D 100 0.00 FLOW WATER JET *100* 0.00 Waterjet Memo 1-Cut as per Dwg D3564 *****(D3564-1F)*****Dwg Rev: **Prog** FLOW CNC Waterjet Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 0.00 OC. Memo Quality Control 120 QC8- Inspect parts - second check 0.00 DAS *120* 17-05-02 QC 0.00 Memo 9-89

DQA:			Date:										
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	Cuffs Contamination			<u> </u>	4	tions Incomplete/	<u> </u>	Part Moved	L	Wrong Stock Pulled			
	Crushing Countersink			<u> </u>	1 `	gned/off center	-	Positioned \		 .			
	Heat Treat Cut Too Short			<u> </u>	Mislab		L	Power Loss/	Surge	Other			
	Inspection Strip in Tube Drawing			Misread									
	Marks/Chatter Drill Holes			Off-set									
	Turning Sequence Finish			<u> </u>	4	Calibration							
	Wave/Twist in Tube			Fit/Function		Out of							

Work Order ID	112435
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112435

Page 2

January-30-14 11:43:18 AM Item ID: D3564-9 Accept *N900040100* Setup Start **Revision ID: Item Name:** Stainless Steel Wearplate Fwd **Start Date:** 1/30/14 Start Qty: 8.00 **Cust Item ID:** ()³ Required Date: 1/30/14 Reg'd Oty: 8.00 **Customer:** Reference: Start Run **Approvals:** Process Plan: Date: **Tooling:** Date: Stop SPC (Y/N): QC: Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID Description** Code Qty **Qty** Number Stamp **Run Hours** 130 0.00 NC BRAKE DAS *130* 30 0.00 Brake NC Memo 9-89 Brake NC Deburr if necessaryForm on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155Form Joggle as per Dwg D3564 on brake using Jig DT 8157 QC5- Inspect part completeness to step on W/O 140 0.00 (11) M-0205 DAS *140* QC 0.00 Memo 9-89 Ensure joggle as per dwg D3429 Quality Control 150 0.00 Large Fab *150* Large Fab 0.00 Memo Large Fab Description BatchA/R 2059B Hardcoat Weld hardcoat as per Dwg D3564

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Work Order ID 112435

112435

Page 3

January-30-14 11:43:18 AM Item ID: D3564-9 Accept *N900040100* Setup Start **Revision ID:** Item Name: Stainless Steel Wearplate Fwd *****2* **Start Date:** 1/30/14 Start Oty: 8.00 **Cust Item ID:** Required Date: 1/30/14 Req'd Qty: 8.00 **Customer:** Reference: Start Run Process Plan: _____ Date: Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Reject Reject **Tool ID** Tool # Plan Accept Insp. Description Qty Stamp **Work Center ID** Qty Number **Run Hours** Code 160 QC10- Inspect visual per QSI004- ground welds 0.00 DAS 9 *160* MODE 9.89 0.00 Memo Quality Control DAS 170 QC5- Inspect part completeness to step on W/O 0.00 9 *170* M-020 9-89 0.00 Memo Quality Control Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00 180 11 8 14-2-12 *120* Powdercoat 0.00 Memo OVEN TEMPERATURE: Powder Coating

FINISH TIME:

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		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld		
		Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong			
		Heat Trea	at			Cut Too Short		Mislab	eled	Surge	Other				
		Inspectio	ection Strip in Tube Drawing			Misread									
	Marks/Chatter Drill Holes			Off-set											
	Turning Sequence Finish			Out of Calibration											
i	Wave/Twist in Tube			Fit/Function		Out of Sequence									

Work Order I	D 112435
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Work Ord January-30-14				*112	2435*						Page 4	
Item ID: Revision ID: Item Name:	D3564-9 Stainless Stee	el Wearplate Fwd		Accept	*N900	0401	೧೧ *	S	Setup Sta	17	S1* S2*	
Start Date: Required Date Reference:	1/30/14 : 1/30/14	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:				14	. 12	
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Sequence ID/ Work Center I 190 *1 QC Quality Control 200 *200 *200 Packaging Packaging	T D	Operation Description QC3- Inspect Part Finish Memo Identify as per dwg & Sto	ck Location:	Set Up/ Run Hours 0.00 0.00 0.00	Tool ID		Code Q	ĺχ_	l		Insp. Stamp	,
210 */21 N* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00			<u>·</u>		Pu-0	1 <u>4-02</u> 12-13	<u>-D</u>	

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	Heat Treat Cut Too Short				Mislabe	eled			Power Loss/	Surge		Other			
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[Marks/Chatter Drill Holes			Off-set											
	Turning Sequence Finish			Out of Calibration											
	Wave/Twist in Tube			Fit/Function		Out of Sequence									

Picklist Print

January-30-14 11:43:18 AM

Work Order ID:

112435

Parent Item:

D3564-9

Parent Item Name:

Stainless Steel Wearplate Fwd

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A

New Issue 07-03-08 ec

IPP Rev:B

As per Rev C 07-07-09 JLM

IPP Rev:C

As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M304S16GA		Purchased	No			100	sf	369.0170	1.41	11.873684		1	4.00	٠٥،
304/316 Sheet .063									•			re 1	4.02	. ق
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	-	Cracks		4	\vdash	Broken/Damage/Defect	-	Hardwa		<u> </u>	Part Incorre	⊢	Temperature/Cure			
	-	Crimp/Kir	ik/Ripple	/Wave	<u> </u>	Burrs	-	1	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	ssing	Weld			
	-	Cuffs			-	Contamination	-	4	tions Incomplete/Unclear	\vdash	Part Moved	·	Wrong Stock Pulled			
	-	Crushing			-	Countersink	-	1 1	gned/off center	\vdash	Positioned V		Othor			
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DART AEROSPACE LTD	Work Order:	112435
Description: Wearshoe	Part Number:	D3564-9
Inspection Dwg: D3564 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.227	_	-	V	Jkm-05
2.432	+/-0.010	2,439			V	
2.50	+/-0.030	2.50	_		v .	
6.000	+/-0.010	6.000	-		au	JKm -06
12.104	+/-0.010	12.104			Τ	
18.000	+/-0.010	18.000	_		T	
18.000	+/-0.010	18,000	_		Τ	
18.00	+/-0.030	18.00	_		Τ	
9.00	+/-0.030	9.00			T	
11.50	+/-0.030	11.50	_		Τ	
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Measured by:	Ae	Audited by:	Prototype Approval:	N/A
Date:	14.02.04	Date: 14.02.05	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.01.16	New Issue	KJ/EC/DD	





